

Date: Thursday, 5/10/2007 2:35:50 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INNER AFT SADDLE
Job Number : 32303	
Estimate Number : 11082	
P.O. Number : N/A	Part Number : D5957
This Issue : 5/10/2007 S.O. No. : N/A	Drawing Number : D5957 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 31531	Material : N/A
Written By : <u>AD 07.05.10</u>	Due Date : 6/5/2007
Checked & Approved By : <u>AD 07.05.10</u>	Qty: <u>14</u> Um: Each
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:F ecn826 06.12.06 ec	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: 1325353mk 07/06/23

14.

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

SA/mk 07/06/23

14

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SA/mk 07/06/23

14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BC 07-06-25

14

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. H07/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *PD*   Date:   07/06/07  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 5/10/2007 2:35:50 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 32303

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 104 144



(14)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR / M-107-06-26

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/6/27 SP



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/6/27

SP/6

(14)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

7/6/27

Job Completion



U 87-0627

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>32303</b>
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	<b>D5957</b>
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.751	1.750	1.751		
C	5.245	5.255		5.250	5.250	5.251	5.250		
D	6.995	7.005		7.000	7.001	7.001	7.000		
E	5.745	5.755		5.747	5.748	5.745	5.750		
F	4.745	4.755		4.748	4.745	4.749	4.750		
G	0.313	0.318	0.315 → 0.322	0.316	0.316	0.317	0.317		
H	1.522	1.532		1.525	1.525	1.525	1.526		
I	3.048	3.058		3.051	3.050	3.051	3.050		
J	4.575	4.585		4.581	4.580	4.581	4.580		
K	0.313	0.318	0.315 → 0.322	0.318	0.318	0.317	0.317		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.502	0.502	0.502	0.502		
N	1.865	1.885		1.877	1.878	1.877	1.877		
O	7.990	8.010		8.001	7.997	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.251	2.250		
Q	0.307	0.312		0.310	0.310	0.310	0.311		
R	0.760	0.765		0.762	0.762	0.762	0.760		
S	0.490	0.510		0.495	0.495	0.495	0.495		
T	1.625	1.645		1.631	1.630	1.632	1.631		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		0.030	0.030	0.030	0.030		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	07.06.21

Audited by:	SG
Date:	07.06.25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>32303</b>
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	<b>D5957</b>
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.436	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.748	1.748	1.749		
C	5.245	5.255		5.251	5.249	5.249	5.249		
D	6.995	7.005		7.000	6.999	6.999	6.999		
E	5.745	5.755		5.751	5.749	5.749	5.749		
F	4.745	4.755		4.750	4.749	4.749	4.749		
G	0.313	0.318	0.315 - 0.322	0.317	0.320	0.320	0.320		
H	1.522	1.532		1.527	1.525	1.525	1.525		
I	3.048	3.058		3.053	3.054	3.054	3.053		
J	4.575	4.585		4.579	4.579	4.579	4.579		
K	0.313	0.318	0.315 - 0.322	0.317	0.320	0.320	0.320		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.502	0.502	0.502	0.501		
N	1.865	1.885		1.877	1.877	1.877	1.881		
O	7.990	8.010		8.000	7.998	8.000	7.998		
P	2.240	2.260		2.255	2.251	2.256	2.256		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.503	0.503	0.503	0.504		
T	1.625	1.645		1.631	1.632	1.630	1.629		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		0.030	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD / JML
Date:	07/06/23

Audited by:	SG
Date:	07.06.25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32303
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	5.245	5.255		5.249	5.249	5.249	5.249		
D	6.995	7.005		6.999	6.999	6.999	6.999		
E	5.745	5.755		5.749	5.749	5.749	5.749		
F	4.745	4.755		4.749	4.749	4.749	4.749		
G	0.313	0.318	0.315 → 0.322	0.320	0.320	0.320	0.320		
H	1.522	1.532		1.525	1.525	1.525	1.525		
I	3.048	3.058		3.053	3.053	3.053	3.054		
J	4.575	4.585		4.579	4.579	4.579	4.579		
K	0.313	0.318	0.315 → 0.322	0.320	0.320	0.320	0.320		
L	0.495	0.505		0.500	0.500	0.500	0.499		
M	0.490	0.510		0.501	0.502	0.502	0.502		
N	1.865	1.885		1.882	1.882	1.881	1.881		
O	7.990	8.010		7.999	7.999	7.999	7.999		
P	2.240	2.260		2.256	2.256	2.256	2.256		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.505	0.505	0.505	0.505		
T	1.625	1.645		1.633	1.630	1.631	1.631		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>MD</i>	Audited by: <i>SG</i>
Date: 07/06/23	Date: 07-06-25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 32303
<b>Description: Inner Aft Saddle</b>		<b>Part Number:</b> D5957
<b>Inspection Dwg: D5957</b>	<b>Rev: B</b>	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

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A	0.438	0.443		0.439	0.439				
B	1.745	1.755		1.749	1.748				
C	5.245	5.255		5.249	5.249				
D	6.995	7.005		7.000	7.006				
E	5.745	5.755		5.749	5.749				
F	4.745	4.755		4.749	4.749				
G	<del>0.313</del>	<del>0.318</del>	.315 → .322	0.320	0.320				
H	1.522	1.532		1.525	1.525				
I	3.048	3.058		3.053	3.054				
J	4.575	4.585		4.579	4.579				
K	<del>0.313</del>	<del>0.318</del>	.315 → .322	0.320	0.320				
L	0.495	0.505		0.499	0.506				
M	0.490	0.510		0.502	0.502				
N	1.865	1.885		1.882	1.882				
O	7.990	8.010		8.000	8.006				
P	2.240	2.260		2.256	2.257				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		0.760	0.760				
S	0.490	0.510		0.502	0.504				
T	1.625	1.645		1.630	1.630				
U	2.000	2.020		2.000	2.000				
V	0.023	0.043		0.033	0.033				
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ml
Date:	07/06/23

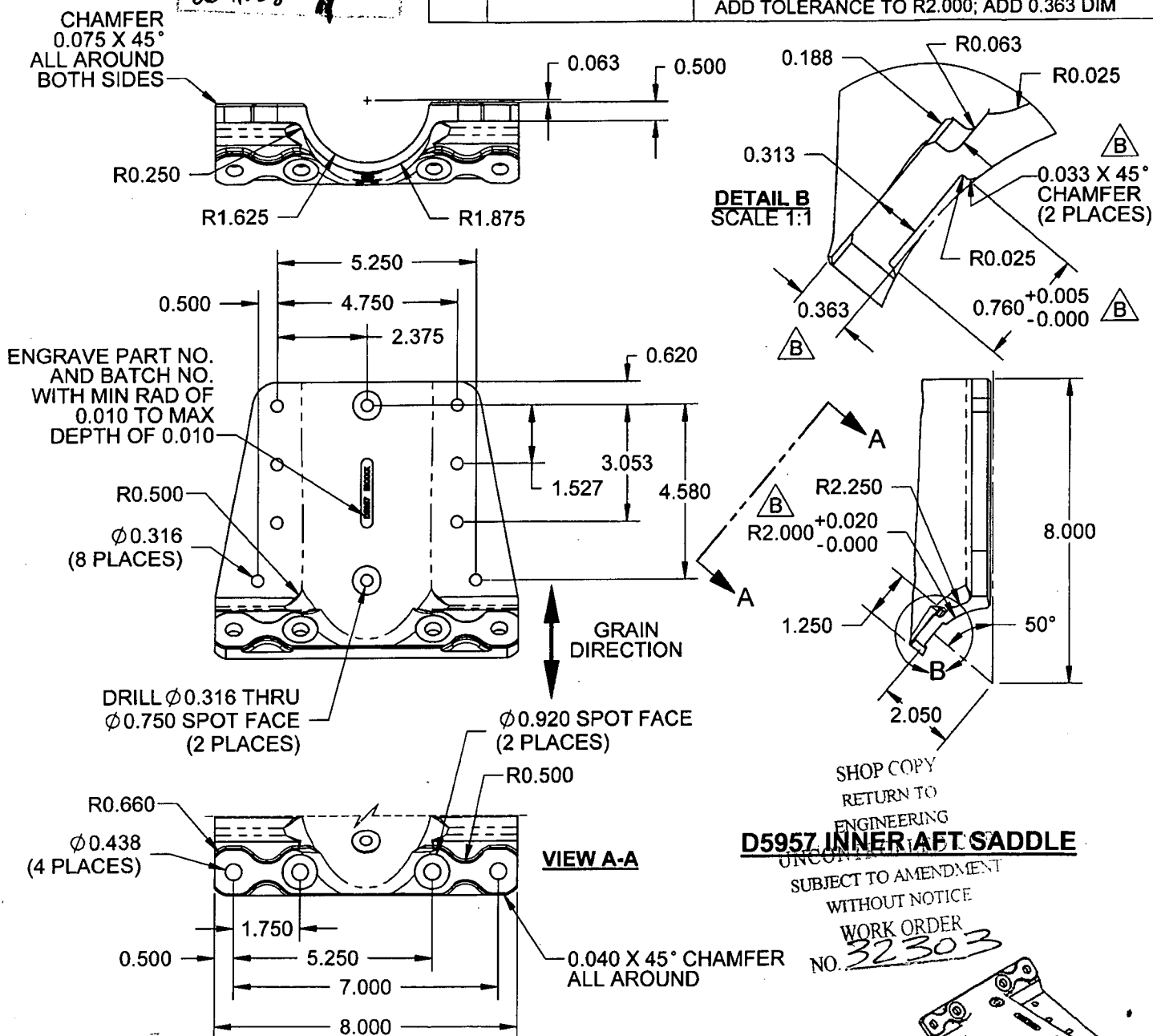
Audited by:	SG
Date:	07-06-23

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
E	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
E	06.12.06	Dimensions L,N,P revised	KJ/EC	





DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D5957</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>		TITLE <b>INNER AFT SADDLE</b>	SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**  
SCALE 1:8

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